

Date: Tuesday, 03/06/2008 1:03:57 PM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 39674	Part Number	: D31991
Estimate Number	: 10283	Drawing Number	: D3199 REV B
P.O. Number	:	Project Number	: N/A
This Issue	: 03/06/2008 S.O. No. :	Drawing Revision	: B
Prsht Rev.	: NC	Material	:
First Issue	: / / Type : SMALL /MED FAB	Due Date	: 15/06/2008 Qty: 40 Um: Each
Previous Run	: 39049		
Written By	:		
Checked & Approved By	: <u>JUL 08.6.03</u>		
Comment	: Est Rev:C Removed Scribing 05-11-05 JLM Est Rev:D As per Rev B 06-11-24 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S20GA	304/316 .040 Sheet
	<p>Comment: Qty.: 0.1040 sf(s)/Unit Total: 4.1580 sf(s) 304/316 0.040" SHEET Batch: <u>108136</u> <u>IB 8-6-9</u></p>	
2.0	WATER JET	FLOW WATER JET
	<p>Comment: FLOW WATER JET Cut as per Dwg D3199 Dwg Rev: <u>3</u> <u>IB 8-6-9</u> Prog Rev: <u>3</u> <u>(44)</u> Deburr if required</p>	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	<p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE</p>	
4.0	QC8	SECOND CHECK
	<p>Comment: SECOND CHECK <u>5 08/06/09</u> <u>(44)</u> <u>coentes</u></p>	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	<p>Comment: SMALL & MEDIUM FAB RESOURCE 1 Form as per dwg D3199 <u>IB 08/06/10</u> <u>(44)</u></p>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BRACKET

Job Number: 39674

Part Number: D31991

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



counts

Comment: INSPECT WORK TO CURRENT STEP

50866/12 x44

7.0

POWDER COATING

POWDER COATING



M 10 5 642



44x

Comment: POWDER COATING

POWDER COATING

Powder Coat Gey Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:50 a.m.
320 °F
8:20 a.m.

m-l 08/06/12

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



4/4

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/06/12

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 233A

08/06/12 x44

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/12

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08.06/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

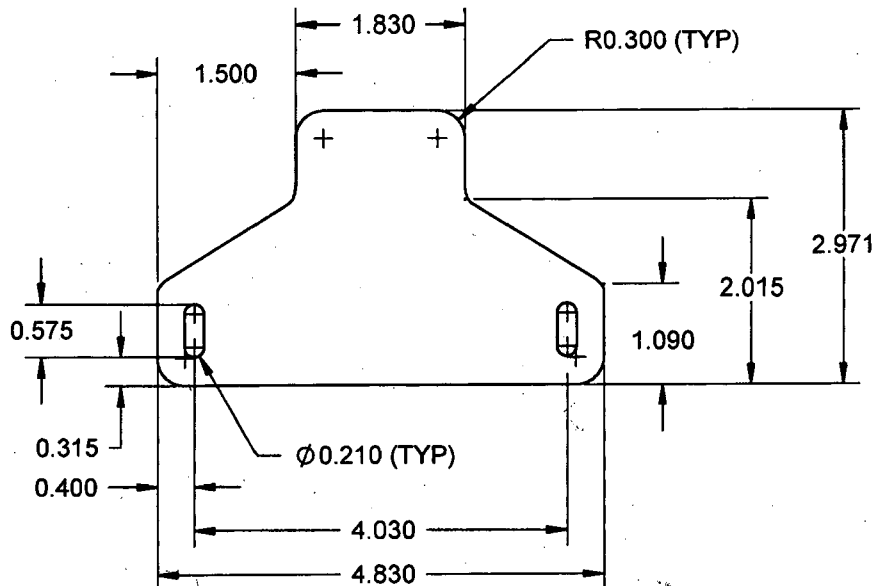
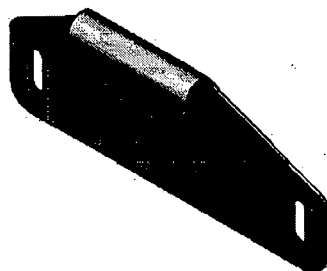
NOTE: Date & initial all entries



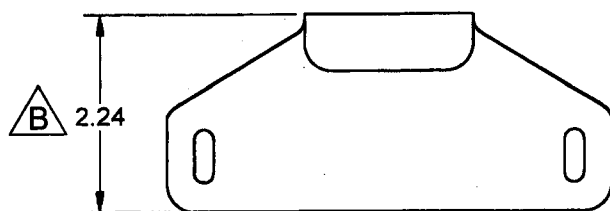
DESIGN <i>QD</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3199	REV. B SHEET 1 OF 1
DATE 06.11.01	TITLE BRACKET SCALE 1:2		
REV	DATE	DESCRIPTION	
A	03.08.05	NEW ISSUE	
B	06.11.01	2.24 WAS 2.142; ADD FINISH; UPDATE DWG	

RELEASED

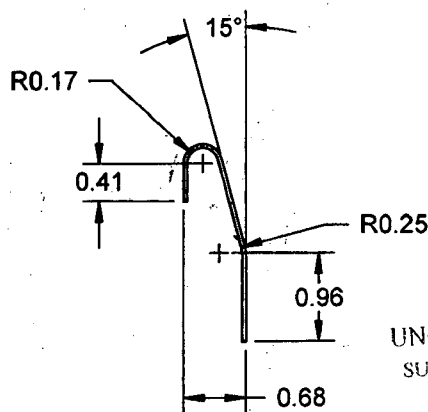
06.11.20 *[Signature]*



D3199-1 FLAT PATTERN



D3199-1 BRACKET



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *39674*

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET 0.040" THICK PER MIL-S-5059 (REF DART SPEC. M304S) ANNEALED
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) AS PER QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3199-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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